Packaging

Work Orde		5376			Page 1							
Item ID: Revision ID: Item Name: Start Date: Required Date:	D3161-7 Hinge 14.0" 8/01/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*	Accept		*N900 Cust Item 1 Customer:		100	ገ*	Setup Sta	1.73	S1* S2*
Approvals:		an: _ML5	Date: 13-08-07				ate:	·	1	Run Sta Sto	17	R1*
Sequence ID/ Work Center II		Operation Description		Set U _I Run F	p/	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr		vision Nbr										
D3161	Rev	v A2				•						
*100 *100* Small Fab Small Fab		Small Fab Memo (i) 72" Hing D3161	ge makes (5) D3161-7 parts	0.00 0.00 at 14" longCu	it to length	as per Dwg			<u>UX</u>			Les p
*110 *110* QC		QC5- Inspect part compl	leteness to step on W/O	0.00	22	00.			4			
Quality Control 120 *120* Packaging		Identify as per dwg & St Memo	ock Location: <u>5703</u>	0.00	08				_4x	<u> </u>	M. D.	13-08-

										DQA:	Date:		
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	AANCE / UP	DATE				
										QA Closed:	Date:		
Work Orde	p				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
WOIK OIGE	·				Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering	
Part No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1 ₇		oforming	Finishing	4	re/Packaging	Other	
NCR N	lo				Work Order Update]	Large Fab Composite Supplier						
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &			
Cause	Date	Step	Qty		or Non-conformance			Descr	iption	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling										!			
Operator							j						
Material													
Setup													
Other]				j							
Process		1											
Supplier [
Training [
Unapproved		}											
				<u>.</u>	F	AULT	CATE	GORY					
Landin	ng Gear			_	General	_				•		•	
Ţ	Bending			L	Bend	∐G	rain			Ovalized		Pressure/Forced	
	Centre Not Concentric to O/S BOM/Route				BOM/Route	Н	ardwai	re		Over/Under	tolerance	Temperature/Cure	
	Cracks Broken/D			Broken/Damaged	ln]	specti	on Incomplete	<u> </u>	Part Incorrec	it	Weld		
	Crushed/Crimped Burrs				Burrs	∐ (n	structi	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs Contamination				Шм	1ainte	nance		Part Moved				
[Heat Trea	et .			Countersink	Шм	lislabe	led		Positioned V	Vrong	•	
	Inspectio	n Strip in	Tube		Cut Too Short	Шм	Iisread			Power Loss/	Surge	Other	
Ţ	Ripples in	n Bend			Drill Holes	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		5376					Page 2	2					
Item ID: Revision ID: Item Name:	D3161-7 Hinge 14.0"	<u> </u>		Accept	*N900	040	100)* s	Setup	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	8/01/13 8/01/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item II Customer:	D:							i
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	· · 	ite:		F	lun	Start Stop	*N *N	R1* R2*	
Sequence ID/ Work Center II 130 *120* QC Quality Coatrol	D	Operation Description QC21- Final Inspection Memo	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty	7	Reject Number	Insp. Stamp	į

N13-08-22

										DQA:	Date:			
NCR: Yes	/ No				WORK ORDER NON-	CONI	FORI	MANCE / UP						
										QA Closed:	Date:			
Work Order:					DISPOSITION	1	AGAINST DEPARTMENT/PROCESS							
Work Gracin					Rework]		Skid-tube	Crosstube		Water Jet	Engineering		
Part No.					Scrap			Machining	Small Fab		d. Eng. Coor	Quality		
NCR No.					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other		
Nek No.					Work Order opdate	¹		reige i an	composite		Juppher			
Root				Descri	ption of work order update	lni	itial	Act	ion	Sign &		·-		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Descr	iption	Date	Verification	QC Inspector		
Doc/Data														
Equip/Tooling		ļ									:			
Operator														
Material														
Setup		ļ									}			
Other														
Process											-			
Supplier														
Training						1								
Unapproved				i										
					F	AULT	CATE	GORY						
Landing (Gear			 	General									

Pressure/Forced Bending Bend Grain Ovalized BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Inspection Incomplete Cracks Part Incorrect Weld Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Crushed/Crimped Burrs Maintenance Part Moved Cuffs Contamination Countersink Positioned Wrong Heat Treat Mislabeled Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Finish Out of Sequence Turning Sequence Folio Wave/Twist in Tube Outside Dimensions

- Picklist Print

August-01-13 11:24:45 AM

Work Order ID:

105376

Parent Item:

D3161-7

Parent Item Name:

Hinge 14.0"

Start Date: 8/01/13

Required Date: 8/01/13

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP A04.08.24New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status /
MS20257-3-7200 Piano Hinge		Purchased	No	·		100	f	72.7870	1,2	4.8	<u> </u>	3/08	100
				Location		Loc Qty	<u>L.</u> c	c Code		./		///	•
				S1209a		72.786956					·		
				1	23960	6.4552628							
				1	25445	6.3316932							
				n	1126275	60			4	.8_			

DQA:	Date:		
•			

Yes / No NCR.

WORK ORDER NON-CONFORMANCE / UPDATE

NCN.	es / NO				WORK ORDER NOW				QA Closed:	Date	;		
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	_	Engineering		
Part N	lo				Rework Scrap Use-as-is	Ther	Skid-tube Crosstube Machining Small Fab			Water Jet E Prod. Eng. Coor. Rec/Store/Packaging			
NCR N	o	Work Order Update					Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier						
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector		
Doc/Data		1											
quip/Tooling													
Operator				•									
Material													
ietup]				1							
Other													
rocess	_	1											
Supplier													
Fraining													
inapproved		<u>l</u>	<u> </u>			1	<u> </u>			<u> </u>	1		
						AULT CAT	GORY						
Landir r	ng Gear			_	General	— .		_	٦		٦. ،		
	Bending			_	Bend	Grain		\vdash	Ovalized	⊢	Pressure/Forced		
- 1	Centre N	ot Conce	ntric to (O/S	BOM/Route	Hardw		\vdash	Over/Under		Temperature/Cure		
-	Cracks			<u> </u>	Broken/Damaged	—	tion Incomplete	⊢	Part Incorre	<u> </u>	Weld		
	Crushed/	'Crimped		Burrs			tions Incomplete/	/Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
,	Cuffs			L	Contamination	\vdash	enance	<u> </u>	Part Moved				
	—	leat Treat Countersink				Mislab		<u> </u>	Positioned V		¬ ₋.		
ļ	Inspection Strip in Tube Cut Too Short				Misrea			Power Loss/	Surge	Other			
	Ripples in Bend Drill Holes				—	Offset							
	Torque Waves in Extrusion Drawing				Out of Calibration								
	Turning S	Turning Sequence Finish					Sequence						
İ	Wave/Twist in Tube Folio					Outsid	e Dimensions						

Wave/Twist in Tube

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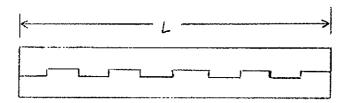




DESIG	H HE	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHEC	KED KA	APPROVID	D3161	REV. A
DATE	02.04	. 24	TITLE HINGE	SCALE NTS
Α	02	.04.24	NEW ISHE	
Al	+:	04.02.27	4DDED D3161-5	
AZ	in-A	04 06 30	ADD 03161-7 & 03161-9	······································

BELEASED

P/N	LENGTH 'L'	DESCRIPTION
D3161-1	13.5"	HINGE (REPLACES MS 20257-3-13.5 ON DZ183)
D3161-3	15.0"	HINGE (REPLACES MS 20257-3-150 ON D2950-041)
11163-5	4.51 "	HINGE
7	14,0"	HINGE
1	17.65	HINGE



NOTES:

1) MAKE FROM MS20257-3-7200 HINGE

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